

Date: Friday, 23/01/2009 8:47:35 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR DOUBLER
 Job Number : 45194
 Estimate Number : 12681
 P.O. Number :
 This Issue : 23/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3594043
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3594 REV B
 Previous Run : 42722 Drawing Revision : B
 Material :
 Due Date : 05/02/2009 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : JUD 09.01.23
 Comment : Est Rev :A New Issue 07-01-22 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s)
 6061-T6 .080 Sheet
 Batch: 110063x8 B 9-2-23

2.0 WATER JET 110254x3 = FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3594
 Dwg Rev: B
 Prog Rev: B

B 9-2-23

2-Deburr if necessary

B 9-2-23

(11)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-2-23

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

509/02/23

(11)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 C'SINK AS PER DWG D3594

509/02/23 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:47:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 45194

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/02/23 (41) - 3

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

B/R 09-02-24 (11)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-24 (4)

9.0	MS210695	Anchor nuts
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Anchor nuts

BATCH: M107938

EP 09/02/24

10.0	MS20426AD44	Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet

BATCH: M15541

EP 09/02/24

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

EP 09/02/24 (11)

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/02/24 (41) - 3

13.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP46060

AS 09/02/24 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:47:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 45194

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/25 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>N5194</u>
Description: Floor Doubler, LH		Part Number: D3594-3
Inspection Dwg: D3594	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

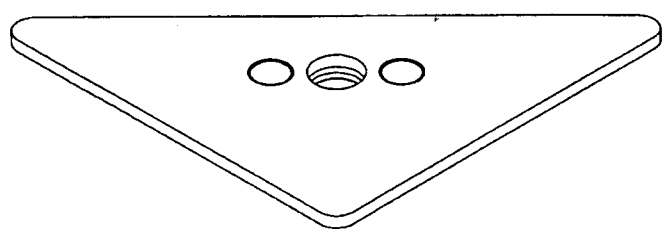
☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.24	+/-0.030	12.24	✓			
7.85	+/-0.030	7.846	✓			
7.313	+/-0.010	7.316	✓			
2.688	+/-0.010	2.685	✓			
Ø0.323	+0.006/-0.001	.326	✓			
Ø0.129	+0.005/-0.001	.132	✓			
0.359	+/-0.010	.359	✓			
0.718	+/-0.010	.718	✓			
0.81	+/-0.030	.815	✓			
2.35	+/-0.030	2.336	✓			

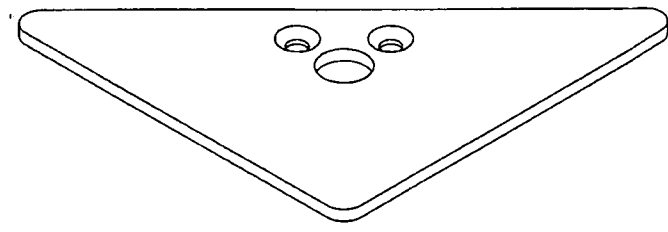
Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-2-23</u>	Date: <u>09/02/23</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue P/O D3594-043	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	

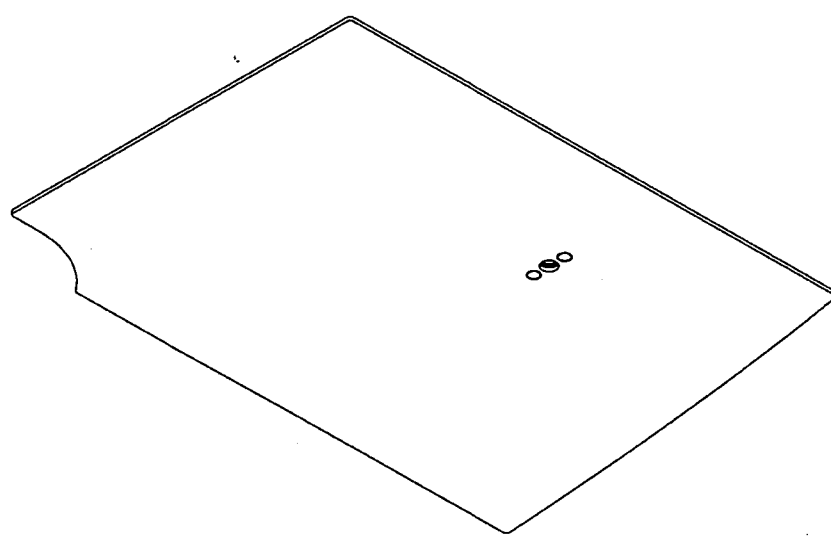
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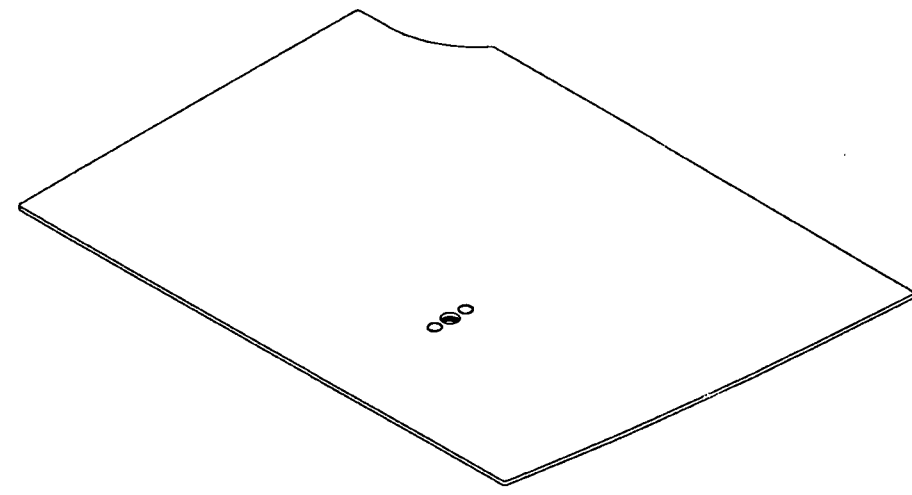
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

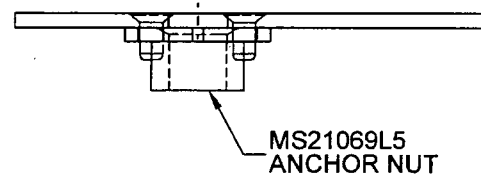
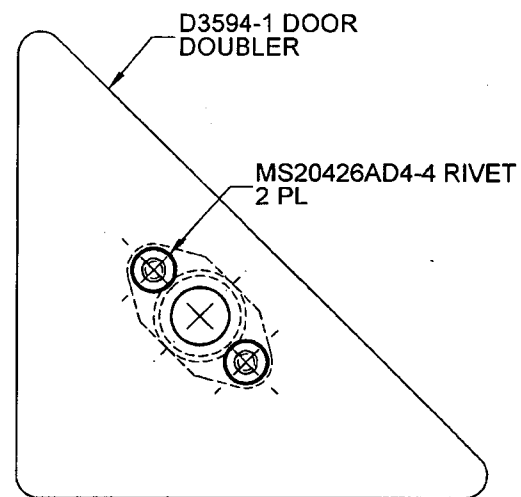
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4594

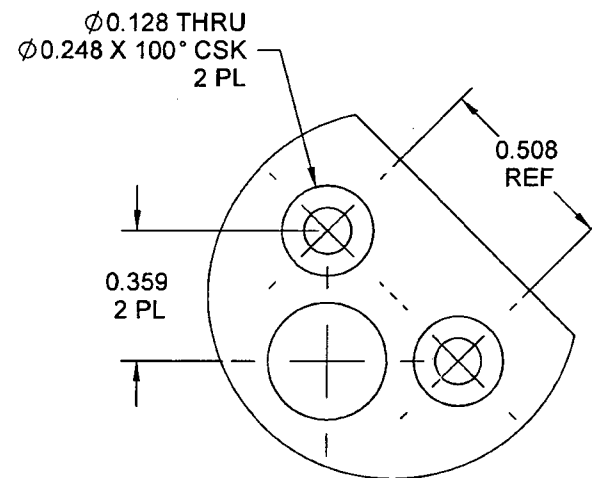
B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
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8 7 6 5 4 3 2 1

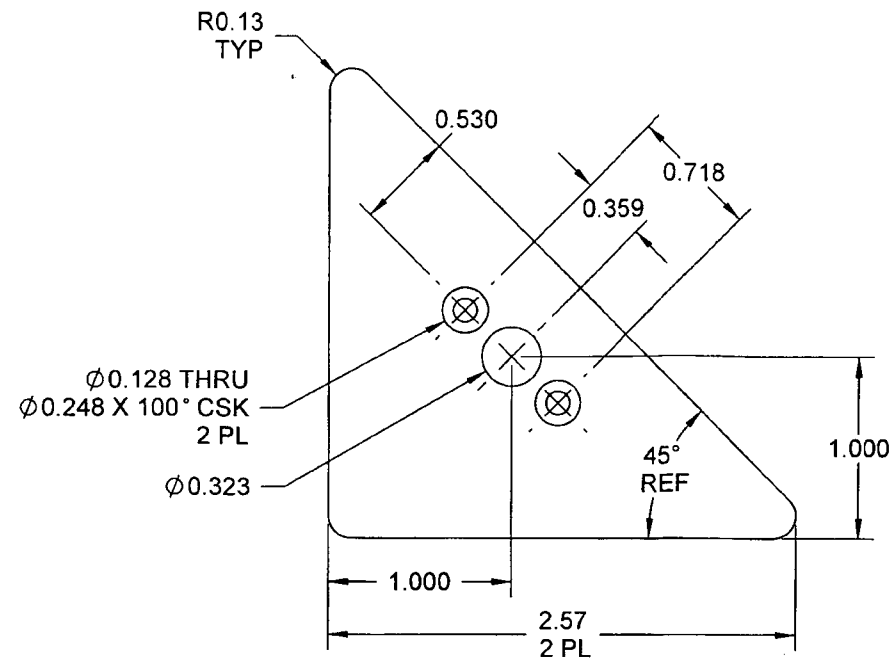
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



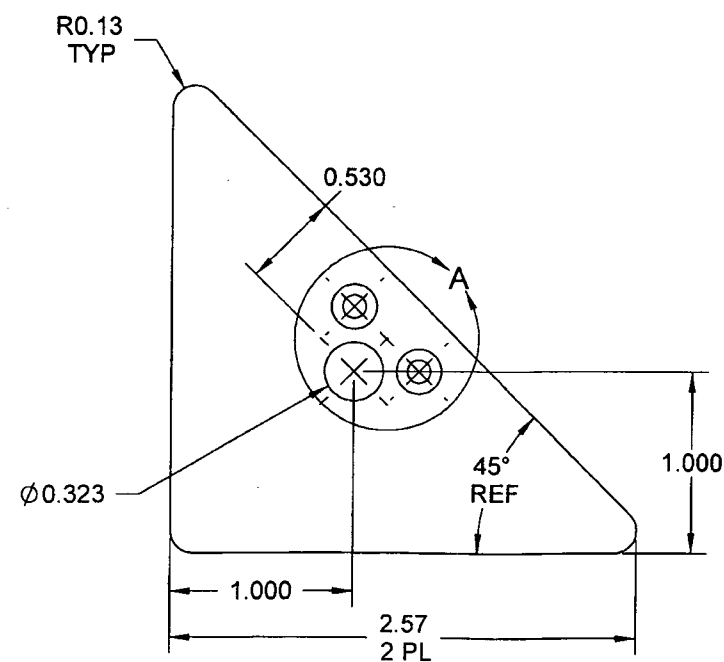
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

NOTES:

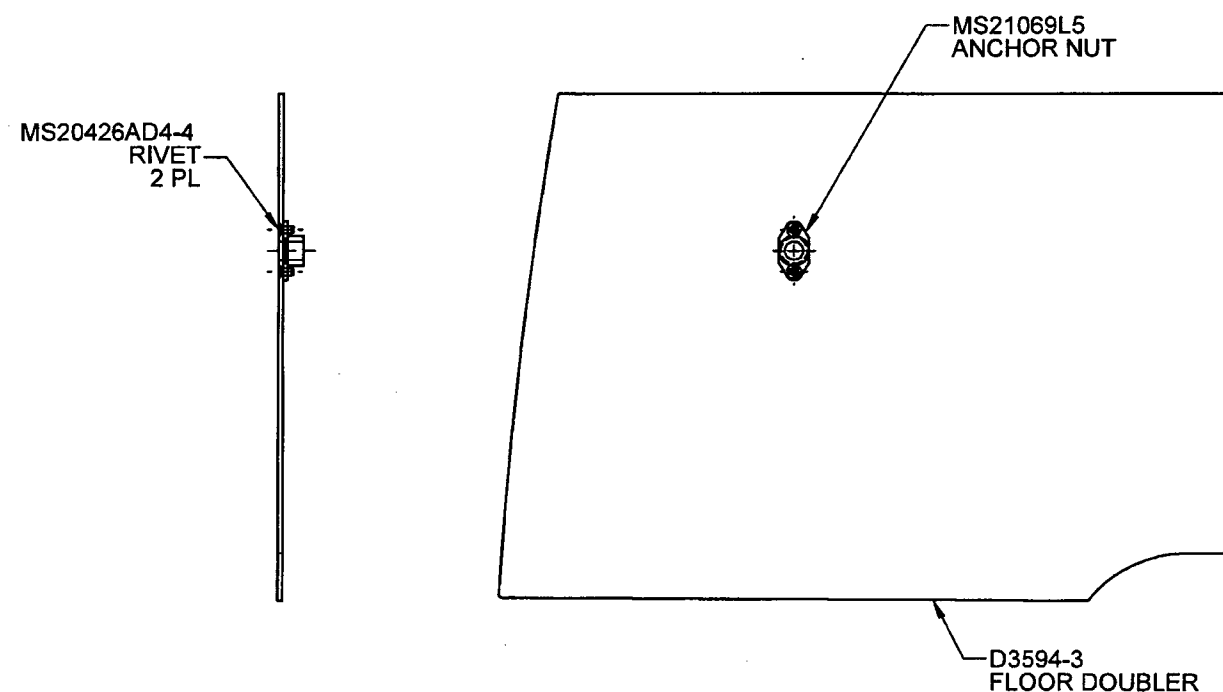
- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

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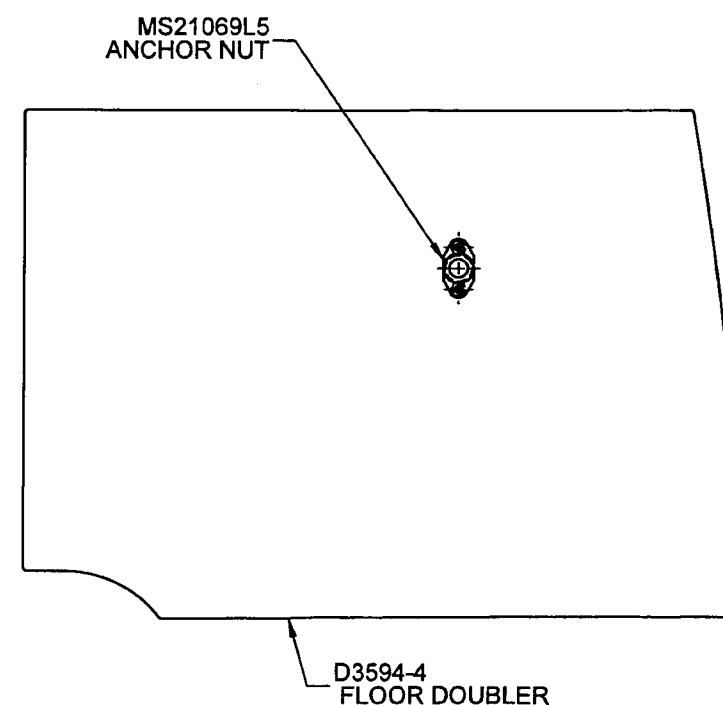
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08-06-26-11

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

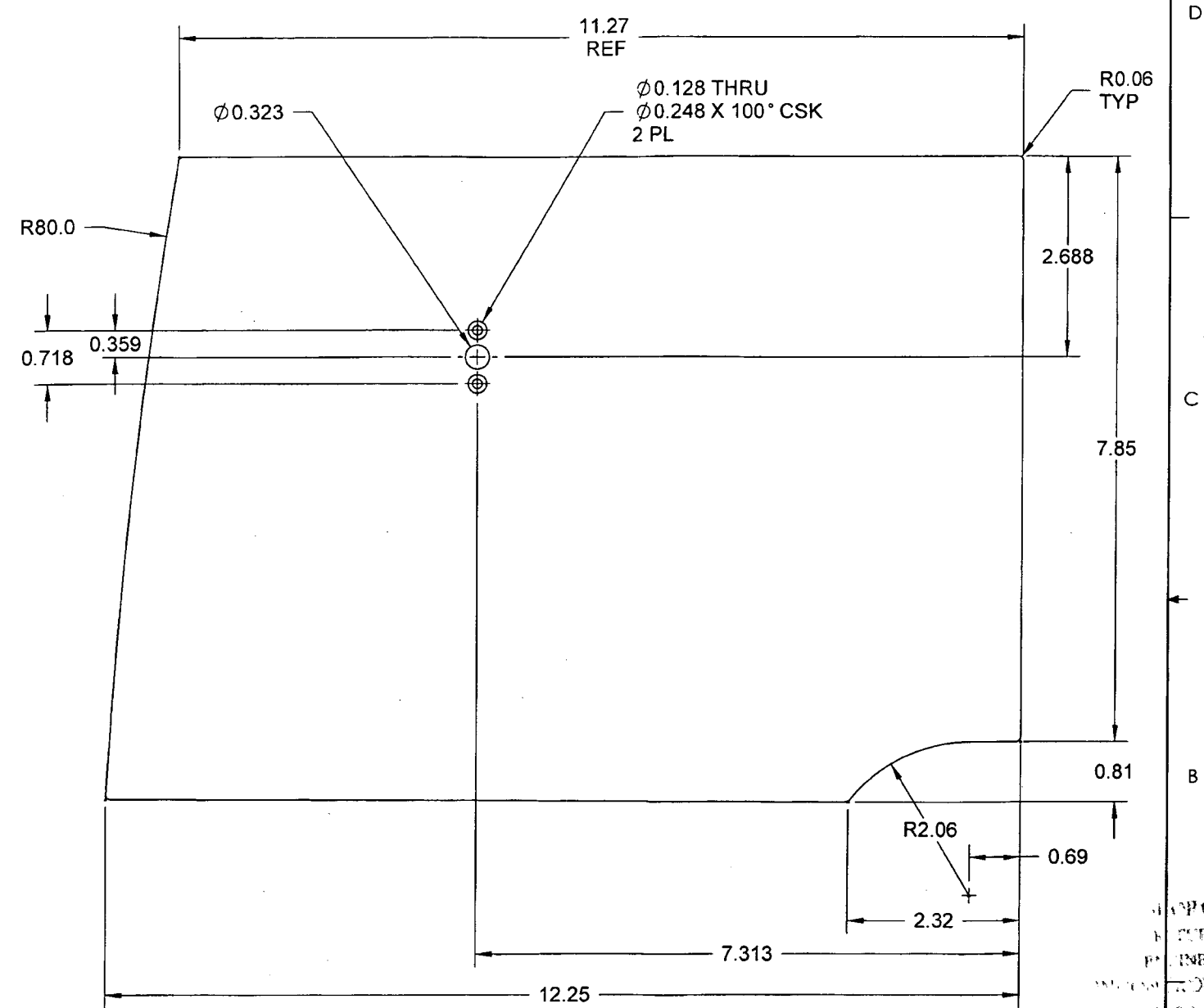
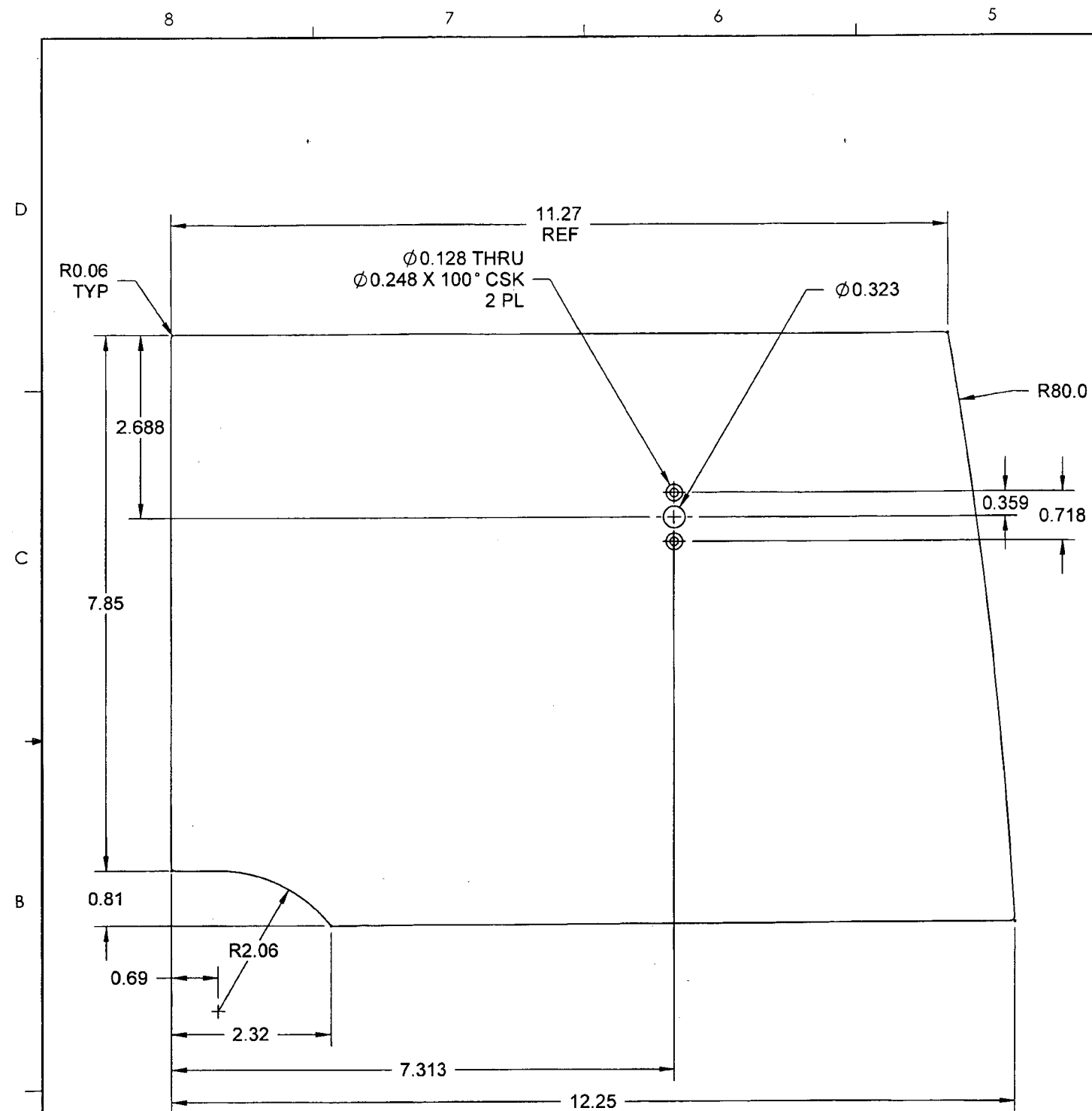
NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR DOUBLER ASSEMBLY	NTS
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